



# Selectarc 24/12S

Rutile type Stainless  
Steel Electrode

## Classification

AWS A5.4 : E309L-16

EN 1600 : E 23 12 L R 3 2

ISO 3581-A : E 23 12 L R 3 2

## Description & Applications

Low carbon Rutile-basic electrode with an austenitic stainless steel deposit containing 15% ferrite for welding dissimilar steels as stainless steels to low alloyed steels. Also suitable for welding high temperature steels and as buffer layer before hardfacing. For repairing of machine parts for civil engineering. First layer on construction steels for 18/8 cladding. Soft fusion, nice aspect of the bead, self releasing slag.

## Base materials

**Stainless steels for general use and for high temperature applications:**

UNS	Alloy	EN	Material N°	UGINE
S30900	309	X15CrNiSi 20-12	1.4828	UGINOX R20-12
S30453	304 LN	X2CrNiN 18-10	1.4311	
S30908	309S	X12CrNi23-13	1.4833	UGINOX R24-13S
		X10CrSi6	1.4712	
		X10CrAl 18	1.4742	

All construction steels, low alloyed in combinations with stainless steels.

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Fe
<0.03	0.8	0.7	22.5	12.5	Rem.

## All Weld Metal Mechanical Properties

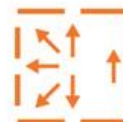
R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>400	>560	>35	+20°C >60

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,0x300	2,5x300	3,2x350	4,0x350	5,0x450
Current	( A )	45	70	100	135	180

Redrying at 250°C during 1 hour, if necessary. Interpass temperature : < 150°C.

ind.12



= + ~ 70V

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